

Work Order ID 60567

Wednesday, July 14, 2010 9:19:10 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 7/14/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: *10-7-15* Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10-7-19

art/ST 10/07/26

art/ST 10/07/26

(12)

12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60567

Wednesday, July 14, 2010 9:19:10 AM

Page 2

Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 7/14/2010 Start Qty: 16.00

Required Date: 7/22/2010 Req'd Qty: 16.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 10/07/27

12

0

151

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

P.P.P
62066

C.W. 7/28 13

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29

P/10-7-28
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:19:15 AM

Page 1

Work Order ID: 60567



Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw


Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	227.7473	3.7	59.2		B10-7-19	

Location

MAT

113903

114624

Loc Qty

227.7473

86.9473

140.8

Loc Code

114624

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60567
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	.072	✓		VERN	
B 5.500	+/-0.030	5.507	✓		V	
C 0.200	+/-0.030	.197	✓		Dept nics	SF 09
D 0.25 x 45°	+/-0.030	.25 x 45°	✓		VERN	SF 12
E R0.250	+/-0.030	.25	✓		Rad gauge	
F 0.250	+/-0.010	.251	✓		VERN	
G 0.625	+/-0.030	.620	✓		"	
H 0.375	+/-0.010	.372	✓		Dep HICS	118-120
I 0.950	+0.030/0.010	.950	✓		VERN	
J 19.000	+/-0.030	19.00	✓		Tape	SF 13
K 3.14	+/-0.030	3.14	✓		VERN	
L 3.28	+/-0.030	3.29	✓		JOYS	
M Ø0.260	+0.005/-0.000	.260	✓		VERN	
N Ø0.93	+/-0.030	.921	✓		VERN	
O 0.30	+0.030/-0.000	.305	✓		VERN	
P 23.750	+/-0.030	23.75	✓		Tape	
Q 7.375	+/-0.030	7.375	✓		VERN	SF 07
R 4.250	+/-0.010	4.25	✓		Depn	SF 12
S 2.000	+/-0.030	2.00	✓		"	"
T 9.000	+/-0.010	9.00	✓		VERN	
U 9.000	+/-0.010	9.00	✓		VERN	
V 0.375	+/-0.010	.375	✓		VERN	

Measured by:	BS
Date:	10/07/26

Audited by:	H.A
Date:	10/07/27

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

—RETURN TO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITH
WORK



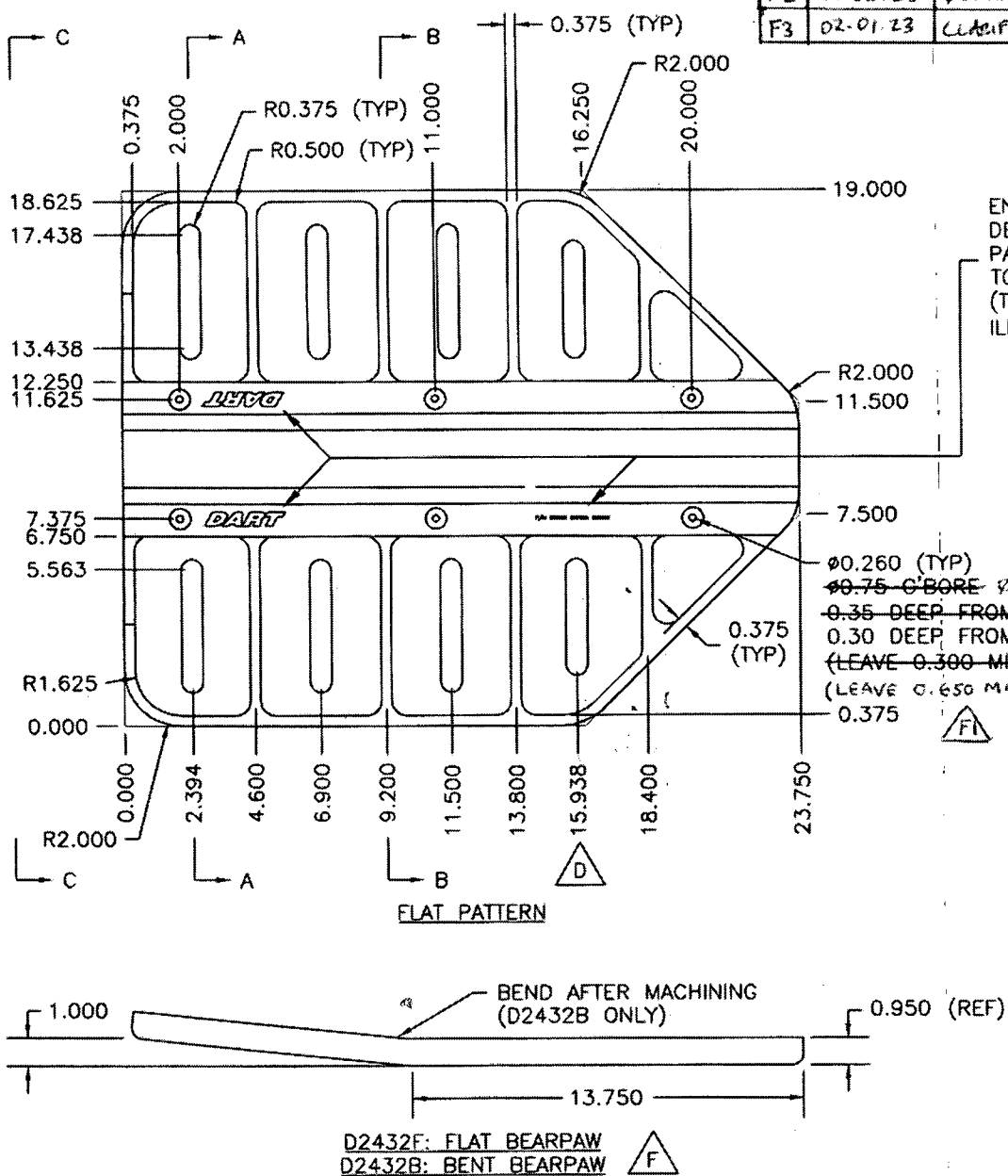
UN

0051
198-10-7-14

DESIGN	<i>KE</i>	DRAWN BY	<i>KE</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. F
CHECKED	<i>mm</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2432	SHEET 1 OF 2
DATE	98.05.12			TITLE	BEARPAW	SCALE 1:6

RELEASED
98-06-17 KES

F1	99.03.03	ADD DEO 9143	
F2	01.03.28	00.93 WAS 00.75	RF
F3	02-01-23	CLARIFY CORE DIMS	RF



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE _____ DEOS

9143

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

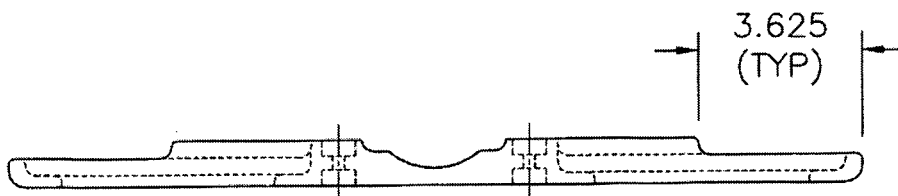
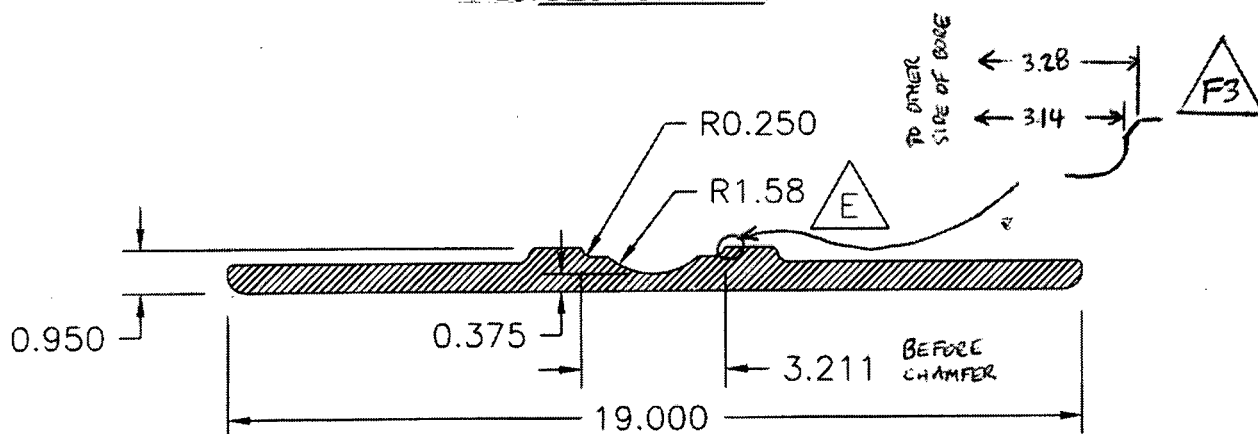
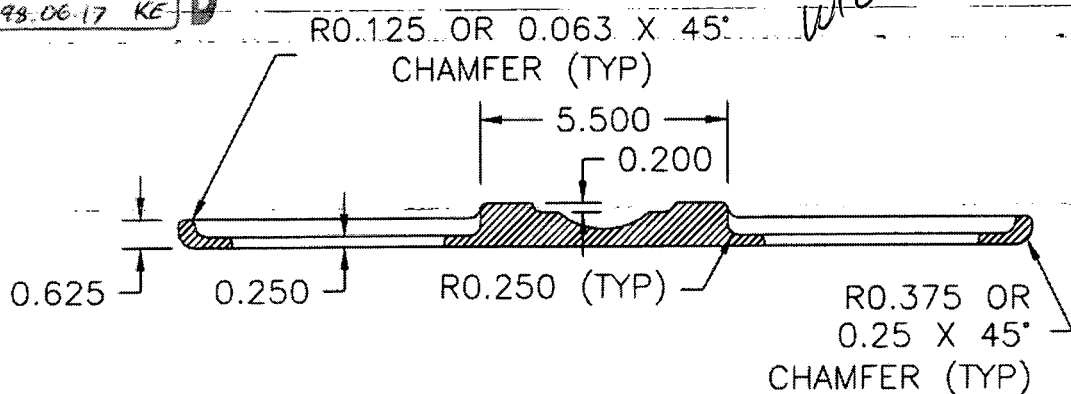
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE

W/O 40567



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries